

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently amended) Method for ~~the~~ dynamic adjustment of roller segments (13 to 17) that support and/or guide both sides of a continuously cast strand (4) made of metal, ~~especially steel,~~ with at least two successive pairs of rollers (18), comprising the steps of: adjusting the pairs of rollers (18) relative to each other with piston-cylinder units (19), which are acted upon with both position control and pressure control; subsequently adjusting the pairs of rollers (18) to the continuously cast strand (4) by position control; switching ~~the~~ hydraulic pressure from position-controlled operation to pressure-controlled operation when the hydraulic pressure in a piston-cylinder unit (19) reaches a predetermined value; installing the roller segments (13 to 17) in a ~~the~~ ~~the~~ hot bar zone, ~~and/or the~~ and a soft reduction zone; and operating the roller segments by an automatic segment control system (32) and a basic automation system (33) so that the method is

applied to roller segments (13 to 17) of continuous bloom and billet casting machines (20).

2. (Previously presented) Method in accordance with Claim 1, further including switching integrated, driven rollers (23) arranged on the segment entrance side (21) and/or on the segment exit side (22) of swiveling and/or parallel-adjustable roller segments (13 to 17) from position-controlled operation to pressure-controlled operation, depending on the phase of the process.

3. (Currently amended) Continuous casting device for casting continuous bloom or billet sections, with a containment roll stand (5), which is arranged after a ~~the~~ continuous casting mold (2), and with a bending-straightening unit (11), wherein a device is arranged at least partially in front of the bending-straightening unit (11) or completely behind the bending-straightening unit (11), with several hydraulically operated piston-cylinder units (19) with position-controlled or pressure-controlled, adjustable roller segments (13 to 17), each of which has at least one driven roller (23).

4. (Previously presented) Continuous casting device in accordance with Claim 3, wherein the driven rollers (23) are installed on the segment entrance side (21) and/or on the segment exit side (22).
5. (Currently amended) Continuous casting device in accordance with Claim 3, wherein a ~~the~~ drive motor (29) ~~(31)~~ for a driven roller (23) is arranged, together with a transfer case (30), on one side (26) of the segment frame (27) with a vertical drive shaft orientation (28).
6. (Currently amended) Continuous casting device in accordance with Claim 3, wherein an ~~the~~ adjustment and automatic control concept (31) for ~~the~~ dynamic adjustment is divided into an automatic segment control system (32) and a basic automation system (33).
7. (Currently amended) Continuous casting device in accordance with Claim 6, wherein the automatic segment control system (32) comprises at least a ~~the~~ given operation strategy (34, 39, 40), roll spring compensation (35), a maximum force regulator (36), a minimum force regulator (37), and a positioning system (38).

8. (Currently amended) Continuous casting device in accordance with Claim 6, wherein the basic automation system 33 comprises at least a ~~the~~ given type of operation (34), a torque controller (39) and a speed controller (40).
9. (Currently amended) Continuous casting device in accordance Claim 3, wherein two pressure sensors (41) spaced some distance apart for different piston positions and a position sensor (42) for a ~~the~~ piston (43) of a piston-cylinder unit (19) are provided on each piston-cylinder unit (19) and are connected with the automatic segment control system (32).
10. (Currently amended) Continuous casting device in accordance with Claim 3, wherein a ~~the~~ drive motor (29) for the driven roller (23) communicates with a ~~the~~ basic automation system (33).